

Date: Wednesday, 22/10/2008 8:20:20 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	02.500 SUPPORT
<b>Job Number</b> :	42785		
<b>Estimate Number</b> :	11058		
<b>P.O. Number</b> :		<b>Part Number</b> :	D28921
<b>This Issue</b> :	22/10/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2892 REV A
<b>First Issue</b> :	11	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41986	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	29/10/2008
<b>Written By</b> :		<b>Qty:</b>	20 Um: Each
<b>Checked &amp; Approved By</b> :	JUD 08.10.22		
<b>Comment</b> :	Est. C 02.11.26 Added P/O KJ Est. D 08.03.19 Re-format EC verified by: DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DSK077	D2892-1 TURNING DETAIL
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**Comment:** Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2892-1 TURNING DETAIL

Batch: B 42245

JL 08/11/26

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS

Machine as per Folio FA082

Tumble &amp; Deburr

JL mwf 08/11/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JL mwf 08/11/27

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JL 08/12/02

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00  
400 OF  
9:30

M-1 08/12/08

20X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 22/10/2008 8:20:20 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.500 SUPPORT

Job Number: 42785

Part Number: D28921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*JD*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-12-08*

*(200)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *X tube assy*

*25 09-02-08*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/26*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-02-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42785
<b>Description:</b> Ø2.500 Support		<b>Part Number:</b> D2892-1
<b>Inspection Dwg:</b> D2892	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132	.136	.134	.135
AB	0.290	0.310		.310	.310	.310	.310	.304
AC	0.040	0.060		.044	.044	.043	.043	.041
AD	0.115	0.135		.126	.126	.126	.127	.127
AE	0.240	0.260		.248	.247	.250	.247	.246
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.140	1.140	1.139	1.142	1.143
AI	0.454	0.474		.464	.464	.455	.456	.458
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.261	.261	.261	.261
AM	1.663	1.683		1.672	1.672	1.669	1.668	1.668
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.783	2.785	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L. / mms Date: 08/11/07

Audited by: [Signature] Date: 08/12/02

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42785
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.134	.134	.134	.134	.134
AB	0.290	0.310		.305	.307	.305	.310	.310
AC	0.040	0.060		.043	.042	.044	.044	.042
AD	0.115	0.135		.127	.128	.125	.127	.127
AE	0.240	0.260		.246	.244	.243	.247	.243
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.149	1.148	1.145	1.145	1.142
AI	0.454	0.474		.458	.461	.462	.463	.463
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.260	.260	.261	.260	.260
AM	1.663	1.683		1.669	1.668	1.666	1.672	1.671
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.783	2.782	2.782	2.783	2.781
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: MMF Date: 08/11/07

Audited by: MK Date: 08/12/02

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42785
<b>Description:</b> Ø2.500 Support		<b>Part Number:</b> D2892-1
<b>Inspection Dwg:</b> D2892	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.115	0.135		.134	.134	.133	.135	.134
AB	0.290	0.310		.300	.310	.310	.310	.310
AC	0.040	0.060		.045	.044	.045	.046	.043
AD	0.115	0.135		.126	.127	.125	.125	.133
AE	0.240	0.260		.244	.250	.250	.246	.246
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.139	1.140	1.140	1.141	1.140
AI	0.454	0.474		.459	.460	.463	.460	.458
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.260	.260	.260	.260
AM	1.663	1.683		1.667	1.667	1.667	1.667	1.668
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.782	2.783	2.782	2.781
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: mmc mof/11/28 Date: 08/11/28

Audited by: mx Date: 08/12/02

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42785	
<b>Description:</b> Ø2.500 Support		<b>Part Number:</b> D2892-1	
<b>Inspection Dwg:</b> D2892		<b>Rev:</b> A	
		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.134	.134	.133	.133	.133
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.045	.044	.044	.045	.043
AD	0.115	0.135		.128	.127	.131	.132	.132
AE	0.240	0.260		.251	.250	.249	.244	.244
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.139	1.138	1.140	1.140	1.139
AI	0.454	0.474		.463	.463	.456	.461	.458
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.261	.261	.261	.261
AM	1.663	1.683		1.667	1.669	1.667	1.669	1.669
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.783	2.783	2.780	2.783	2.782
AQ								
AR								
AS								
AT								
Accept/Reject								

**Measured by:** nmc **Date:** 08/11/20

**Audited by:** [Signature] **Date:** 08/12/02

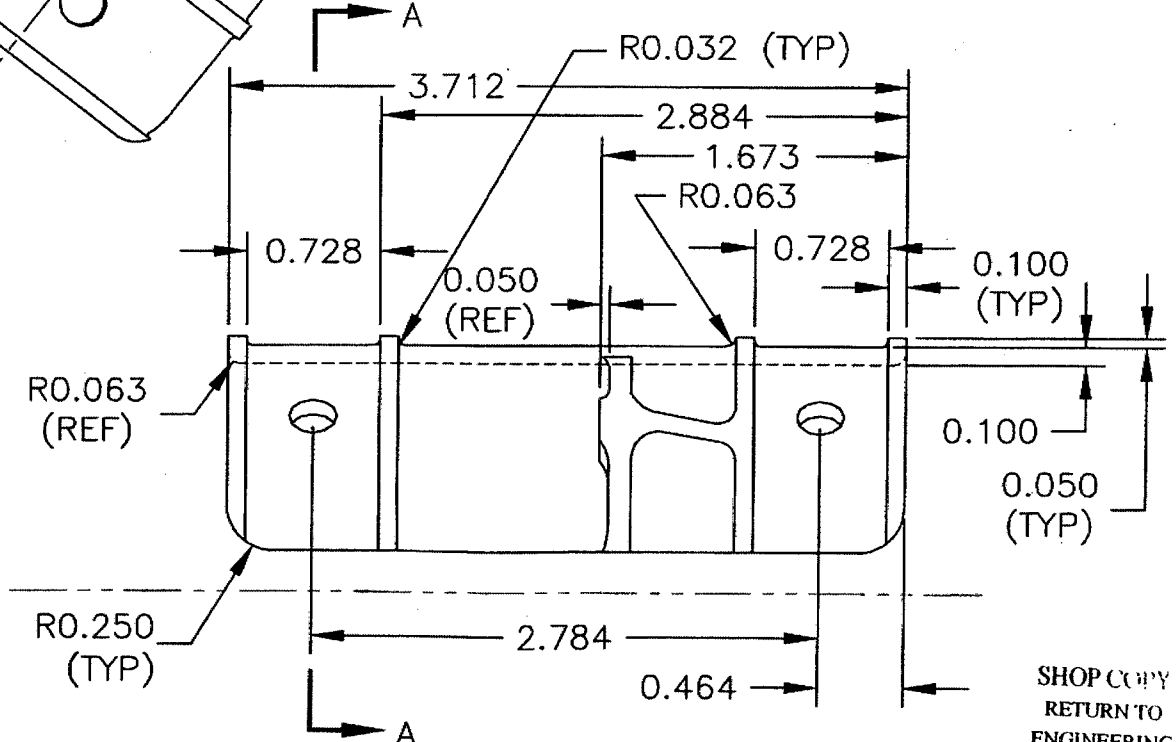
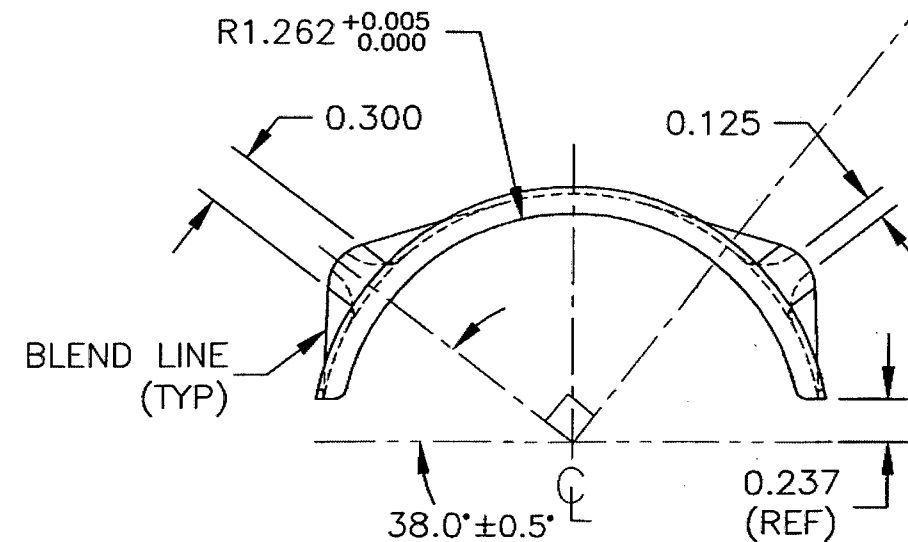
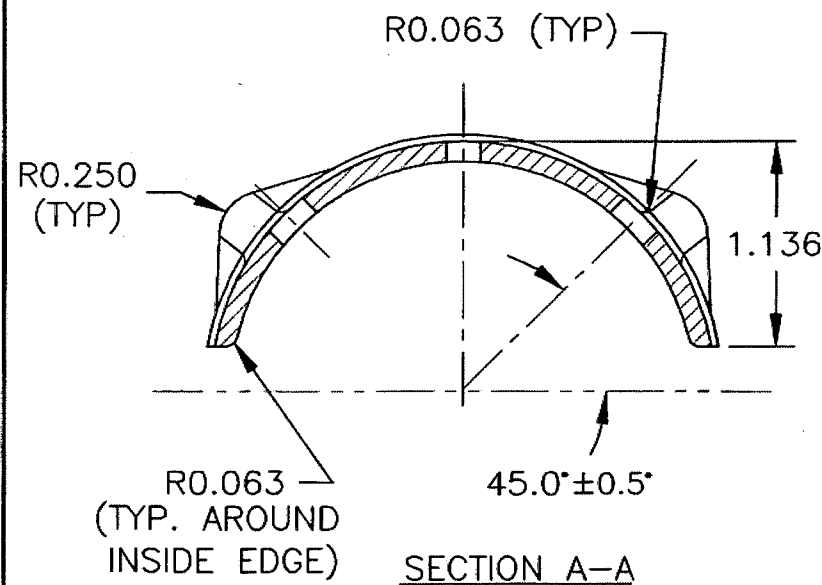
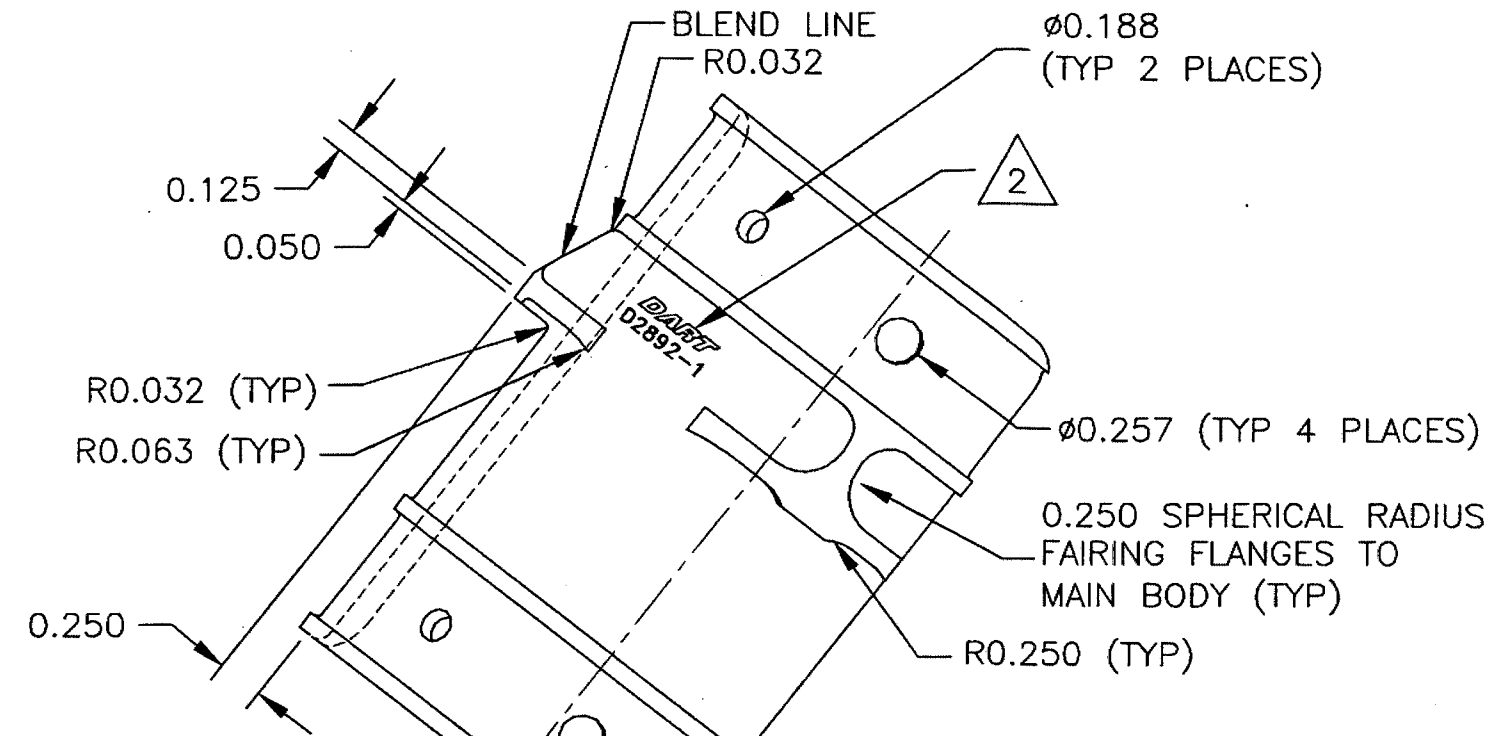
**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	[Signature]



D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42785

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DART AEROSPACE LTD.

A	00.11.17	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	CP	APPROVED	CP
DATE	00.11.17	TITLE	2.500 SUPPORT
		DRAWING NO.	D2892
		REV. A	SHEET 1 OF 1
		SCALE	1:1

**DART**

**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA